

**Work Order ID 62971**

Thursday, October 14, 2010 12:41:44 PM

Page 1

Item ID: D3391-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Tube Assembly

Start Date: 10/14/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

DP

10-10-20

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391

DP

10-10-20

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

1 10-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA590 Rev. _____ & Dwg D3391 Rev. _____ Identify as D3391-1  2-Deburr	0.00  0.00				/			
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00				/			
150  Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE  Memo 1-Drill .1875" at end of tube as per Dwg D3391	0.00  0.00							

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

*10/11/17*

Quality Control

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*10/11/22*

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Drill and c'sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(DRILL ALL HOLES)

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr and scribe batch # inside aft end

7- transfer drill D3391-011 with D3391-013

DP

10-12-1

BE 10/11/29

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/12/10

X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 9 JE 10/20/06

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391  
A/R Magnabond 6398 batch: M115580

Exp- 07-2011

DP 10-12-6

2- Grind flush

3- back drill crossbolt if necessary

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/12/13

Memo

0.00

AL

235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=&gt; 10/12/13

Memo

0.00

LAND REALODINE AS PER PAR09-043

1 6

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/5/11

Memo

0.00

START TIME: 8:50  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:20

1 BR 11-2-28.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 20 11/02/28

255

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

✓ \*\*\*\* install D3591-1 spacer as per DSI9364 and wearplate and gasket as per  
DWG \*\*\*\*

1 0 20 11/02/28

257

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/2010

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 62971**

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Start Date: 10/14/2010 Start Qty: 1.00

Required Date: 10/22/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260



Packaging

Packaging

Identify as per dwg & Stock Location: W/O

0.00

Memo

0.00

D412-742-041 / 62982

1 0 11/03/10

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/03/10

11-03-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, October 14, 2010 12:41:48 PM

Page 1

Work Order ID: 62971

Parent Item: D3391-011

Parent Item Name: Fwd Tube Assembly



Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.09.13 New issue KJ/JLM  
 IPP B 06.02.09 Dwg rev.D EC  
 IPP C 07.03.13 revF dwg ec  
 IPP D 07.11.01 ecn1053P EC  
 IPP Rev:E ECN 1056 07-11-12 DD verified by:EC  
 IPP Rev:F 08-09-08 new process (ecn 08-510) DD verified by:EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 10.04.07 add part in bom DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047 		Manufactured	No			100	Each	36.0000	1	1			
Skidtube Material													

Location	Loc Qty	Loc Code
LG	36	
23935	3	
26547	33	

D3401-041 		Manufactured	No			255	Each	13.0000	1	1			
Tow Cap Assembly													

Location	Loc Qty	Loc Code
FP	13	
46029	12	
50316	1	

D3564-13 		Manufactured	No			255	Each	31.0000	1	1			
Wearshoe													

Location	Loc Qty	Loc Code
FP17	31	
59660	1	
60862	8	
61828	10	
62229	12	

① 10-10-20  
 11/02/25  
 11/02/25  
 11/02/25

B65522 xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item: D3391-011

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Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No

255

Each

31.0000

1

1



Gasket



*Handwritten:* 11/02/20

Location

Loc Qty

Loc Code

FP012

31

*Handwritten:* 36-1076

*Handwritten:* X1

60209

6

61996

25

D3670-4-200 Manufactured No

220

Each

64.0000

9

9



SPACER



Location

Loc Qty

Loc Code

LG

64

*Handwritten:* 57349

64

D3672-1 Manufactured No

255

Each

855.0000

4



Phenolic Washer



*Handwritten:* 10-12-6  
X4

Location

Loc Qty

Loc Code

ST077

855

42329

150

52505

705

*Handwritten:* X4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No  
BOLT

255 Each 1,361.000 10 10



Handwritten: 11/02/25

Location

Loc Qty

Loc Code

ST303

3

M116704

x10

115438

3

ST350

1358

114108

14

114416

12

114523

2

115300

330

115589

1000

AN960C10L NAS1149C0332 Purchased No

255 Each 29.0000 10 10



washer



Handwritten: 11/02/25

Location

Loc Qty

Loc Code

ST245

29

M116304

x10

107534

29

AELS-1032-130 Purchased No

255 Each 0.0000 2 2



INSERT

M115581



Handwritten: (x2) 11/02/25

AELS-1032-225 Purchased No

255 Each 0.0000 10 10



INSERT

M110768



Handwritten: (x10) 11/02/25

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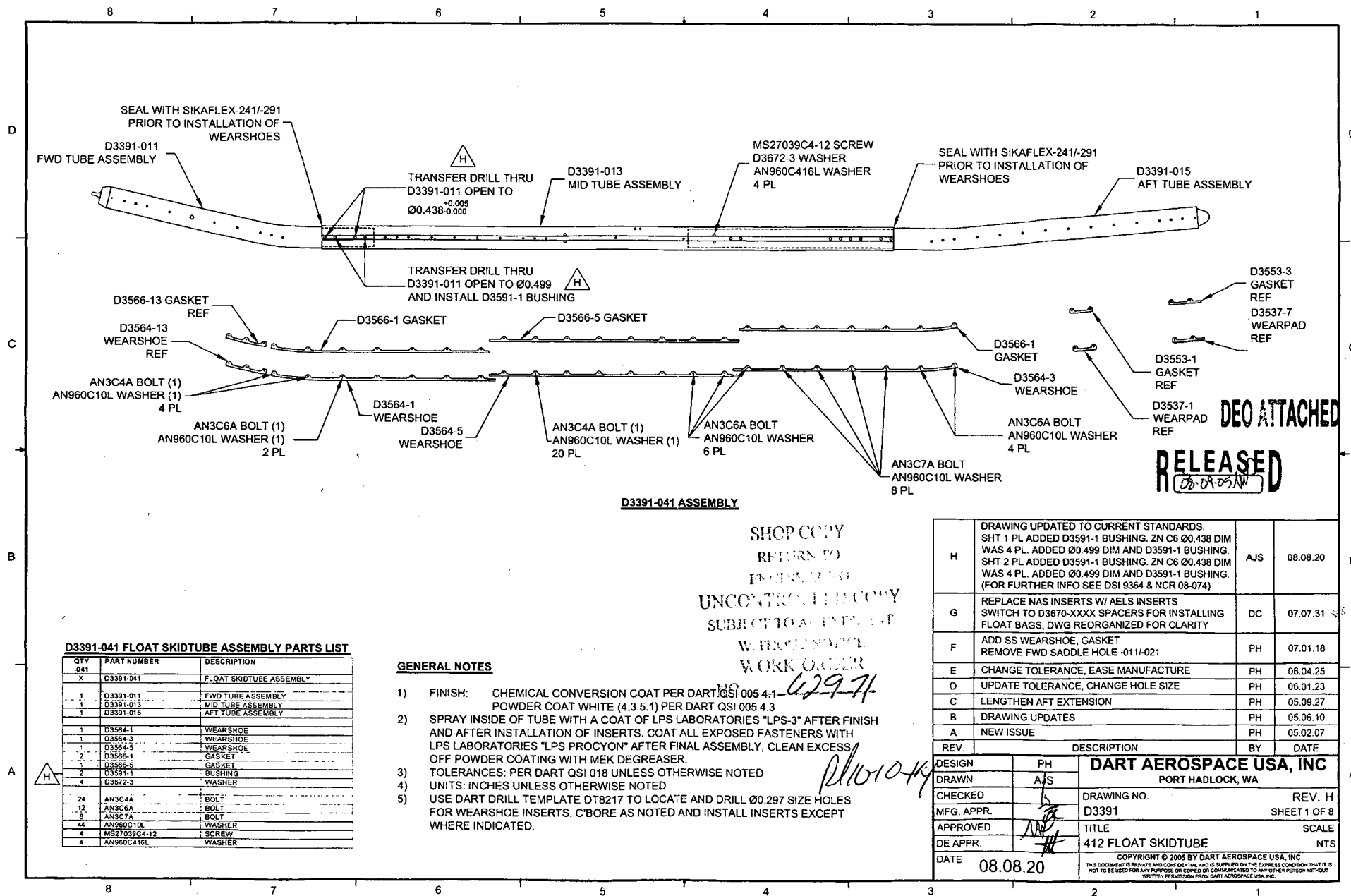
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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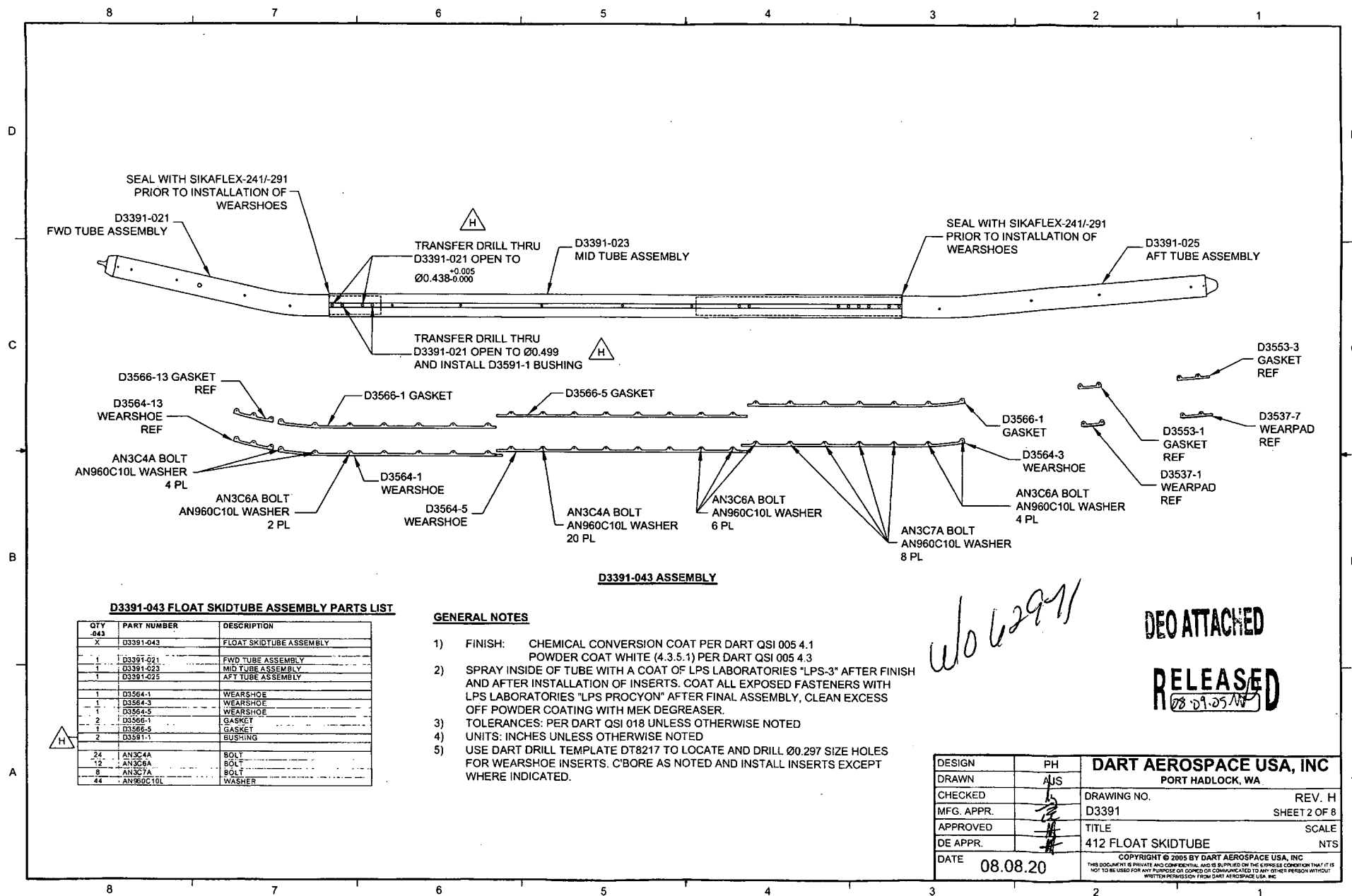
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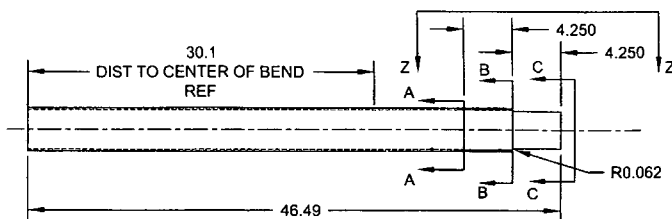
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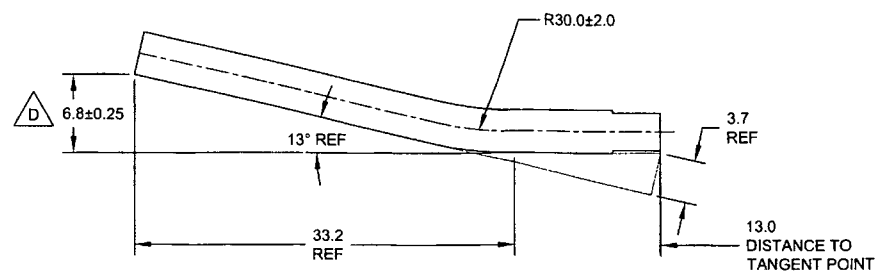
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

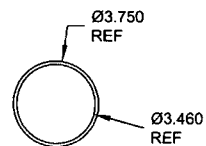
**NOTE:** Date & initial all entries



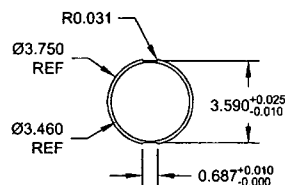
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



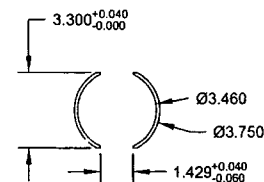
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



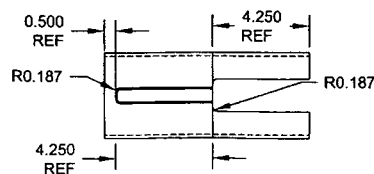
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

*W/O 62971*

DESIGN		PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN		AUS	PORT HADLOCK, WA	
CHECKED			DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 3 OF 8	
APPROVED			TITLE	SCALE
DE APPR.			412 FLOAT SKIDTUBE	NTS
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**DEO ATTACHED**  
**RELEASED**  
*08-05-11*

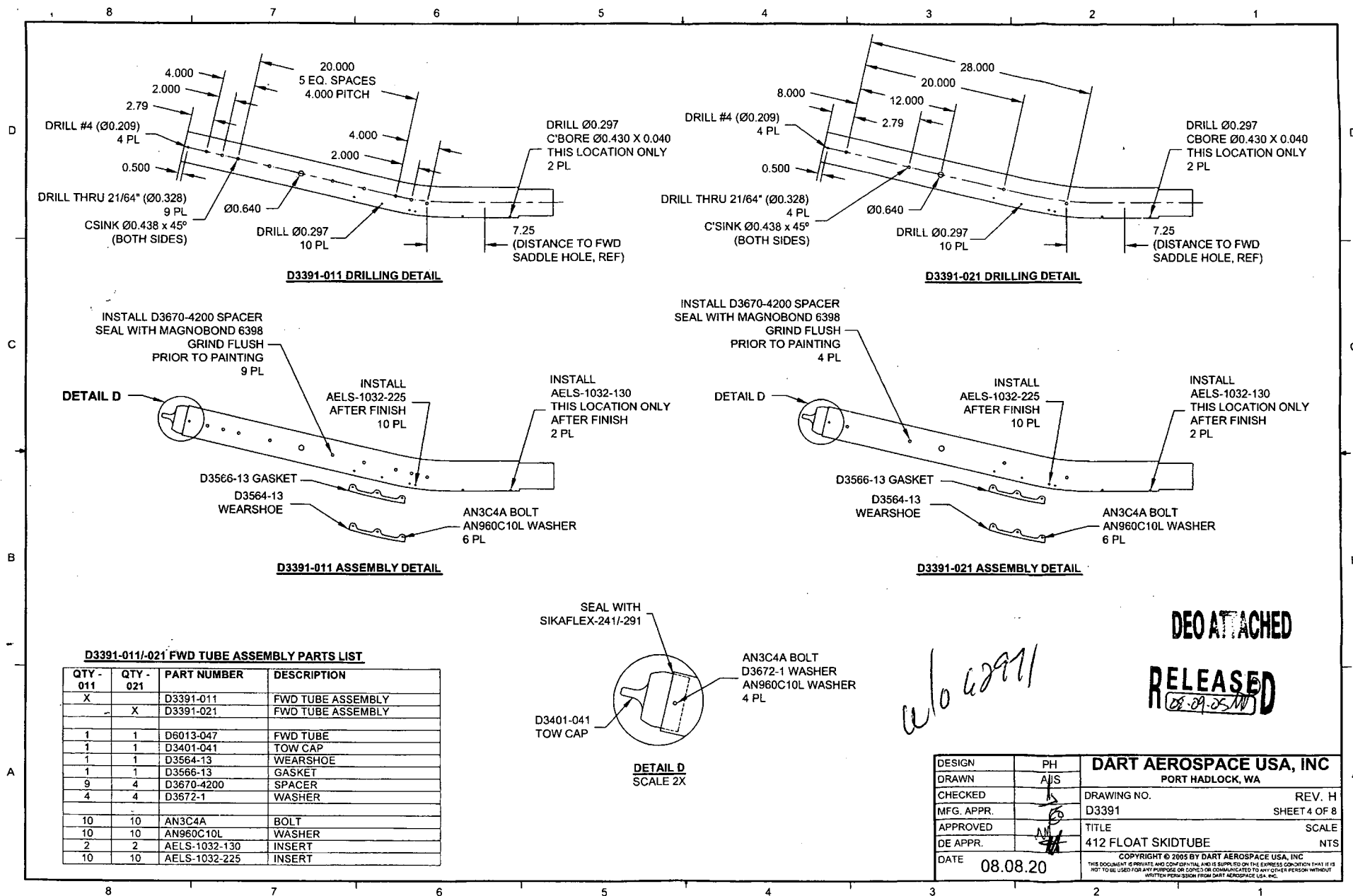
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

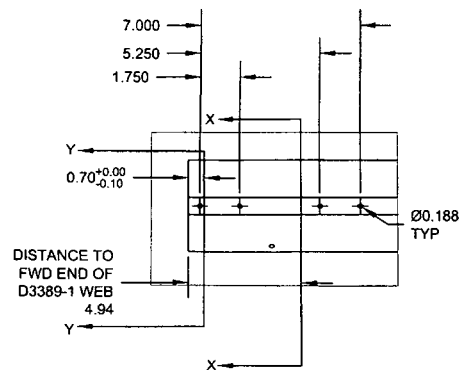
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

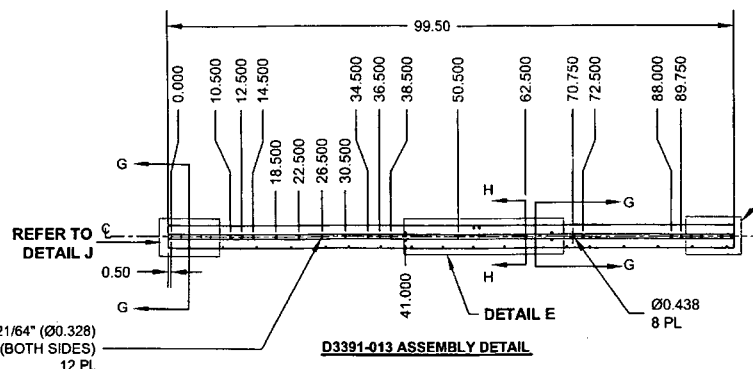
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

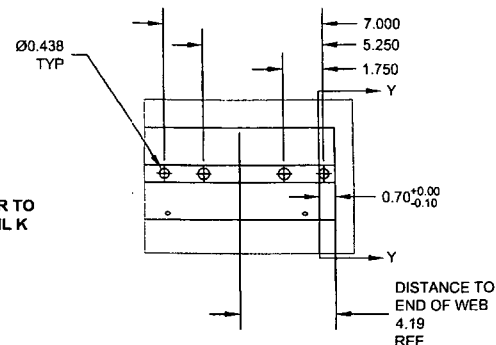




**DETAIL J**  
SCALE 4X



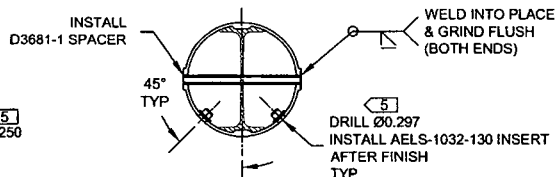
**D3391-013 ASSEMBLY DETAIL**



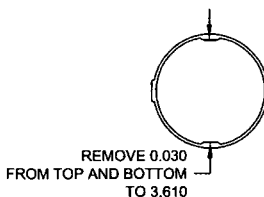
**DETAIL K**  
SCALE 4X



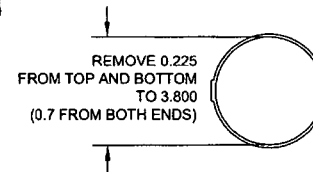
**SECTION G-G**  
SCALE 5X



**SECTION H-H**  
SCALE 5X



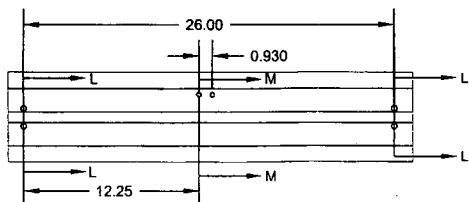
**SECTION X-X**  
SCALE 5X



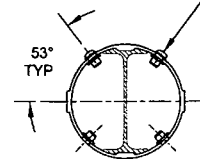
**SECTION Y-Y**  
SCALE 5X

**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

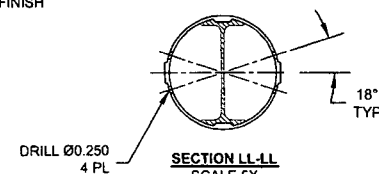
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



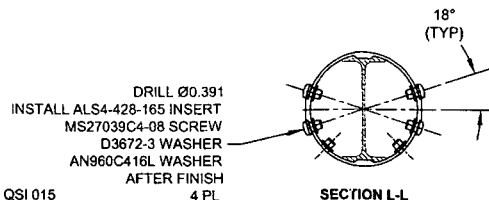
**DETAIL E**  
SCALE NONE



**SECTION M-M**  
SCALE 5X



**SECTION LL-LL**  
SCALE 5X





**SECTION L-L**  
SCALE 5X

**D3391-013 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2411-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
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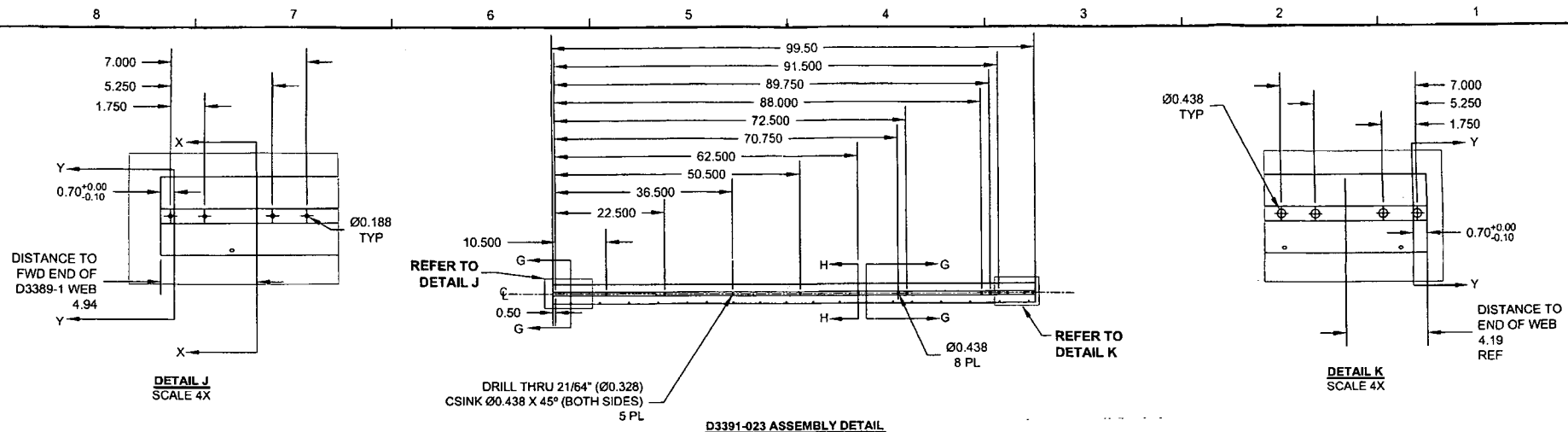
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

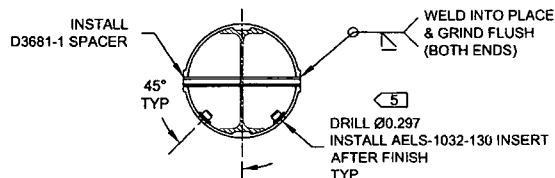
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

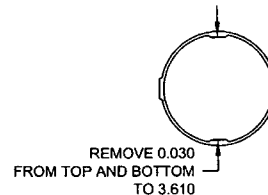
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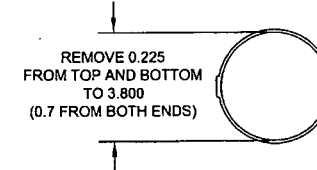
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AS	PORT HADLOCK, WA	
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MFG. APPR.		D3391	SHEET 6 OF 8
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DEO ATTACHED  
RELEASED  
08-08-20

*also 02971*

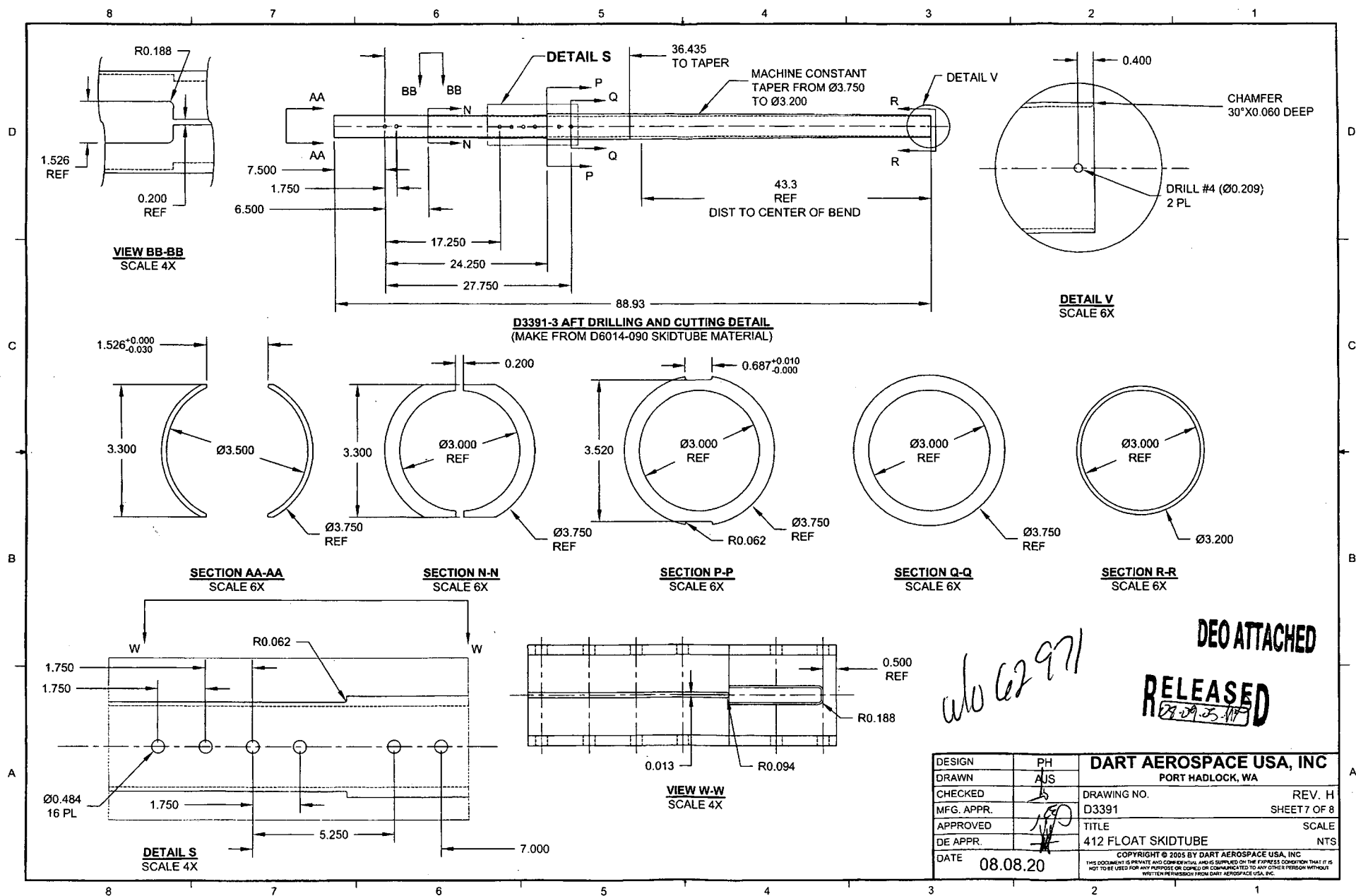
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



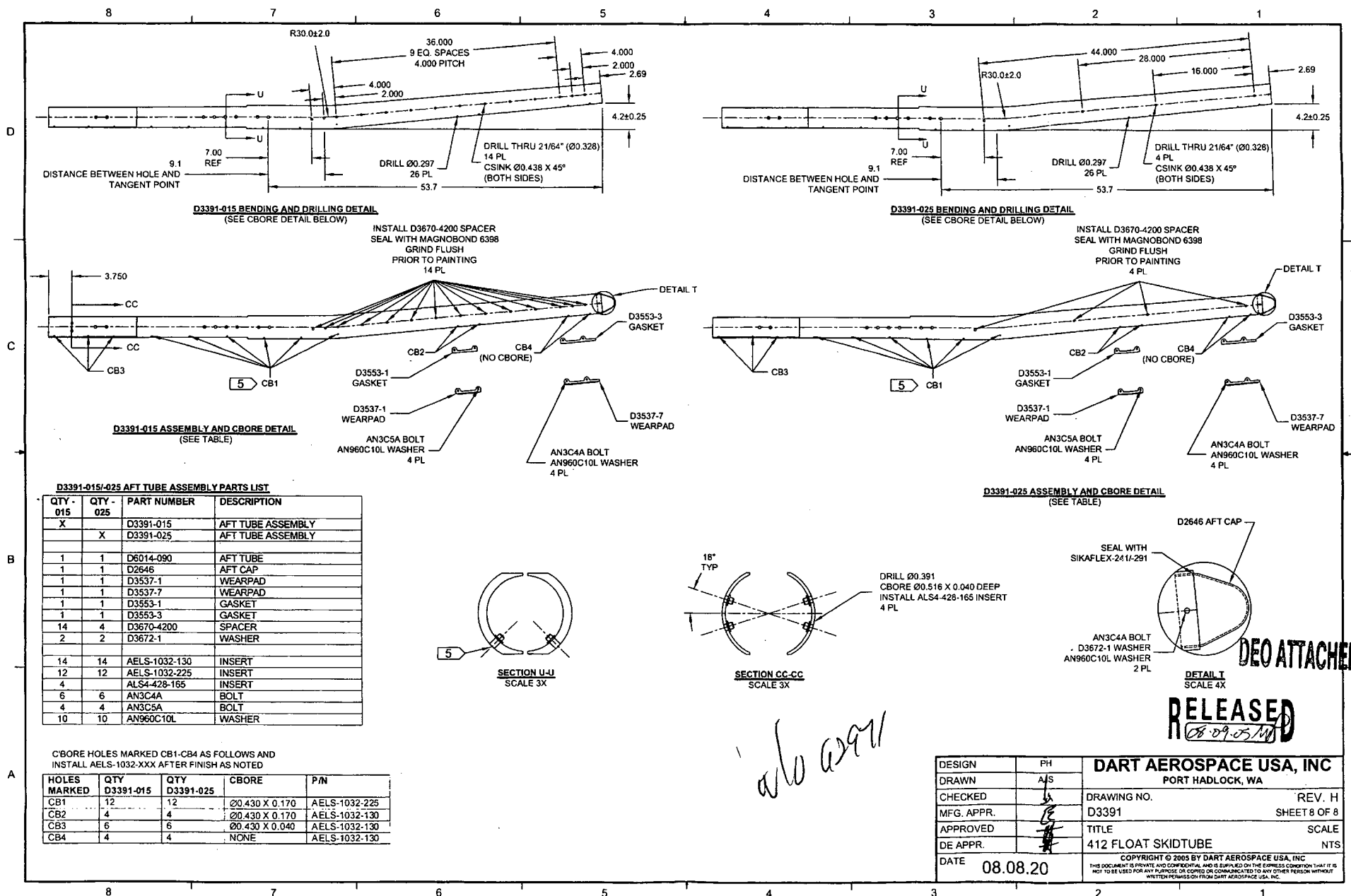
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
							/	

**NOTE:** Date & initial all entries



DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>	DE APPR. <i>h</i>			
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30			

**PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

**CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~  
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~  
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
 OFF POWDER COATING WITH MEK DEGREASER.

**RELEASED**  
 2010-02-02

*MP*

*WLO 62971*

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